

DELRIW . 750

M delrin 3/4

Work Order ID 128091

128091

Page 1

Tuesday, January 06, 2015 9:56:05 AM

Item ID: D3532-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Spacer

Start Date: 1/6/2015 Start Qty: 40.00

40

Cust Item ID:

Required Date: 1/6/2015 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: MJS Date: 1501-06 Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3532	Rev A

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA643 & DWG D3532 ,FOLIO
REV: _____ DWG REV: _____ 2-DEBURR AS REQUIRED

40	Ø	DAS 37 9-89	15-01-24
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110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

40	Ø	DAS 37 9-89	15-01-24
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120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

40	Ø	DAS 40 9-89	15/01/25
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 128091

128091

Page 2

Tuesday, January 06, 2015 9:56:05 AM

Item ID: D3532-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacer
Start Date: 1/6/2015 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 1/6/2015 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>Stoys</u>	0.00							
130						<u>40</u>		<u>ML5</u>	<u>1501-26</u>
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

15/1/28 MF

15-1-26

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Training									
Transport									
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Picklist Print

Tuesday, January 06, 2015 9:56:08 AM

Page 1

Work Order ID: 128091

128091

Parent Item: D3532-1

D3532-1

Parent Item Name: Spacer

Start Date: 1/6/2015

Required Date: 1/6/2015

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 06-07-12 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDEL RINR0.750		Purchased	No				f	34.2730		2		DAS	
MDFI RINR0 750									**			37	
Delrin Round Bar 0.75" color: black												9-89	15-01-2

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT039	34.273	
m127442	8.1	
m129148	2.083	
m130432	24.09	

2-84

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

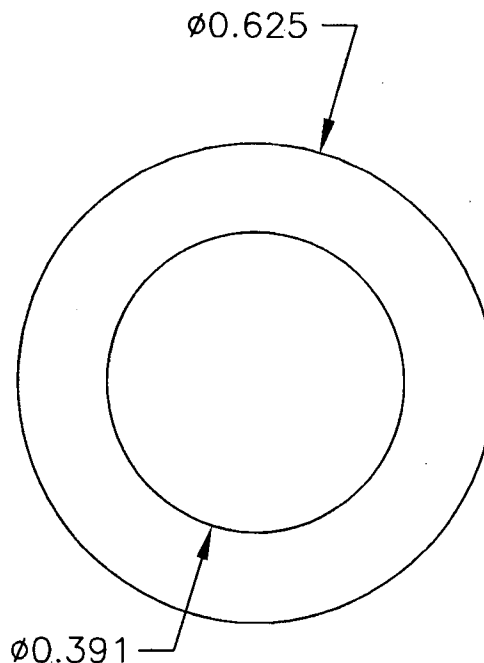
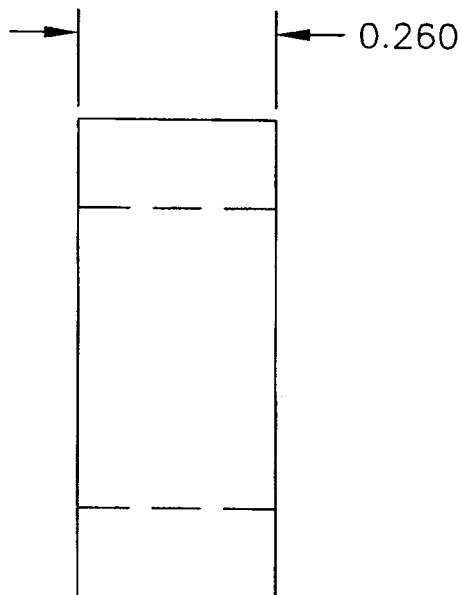
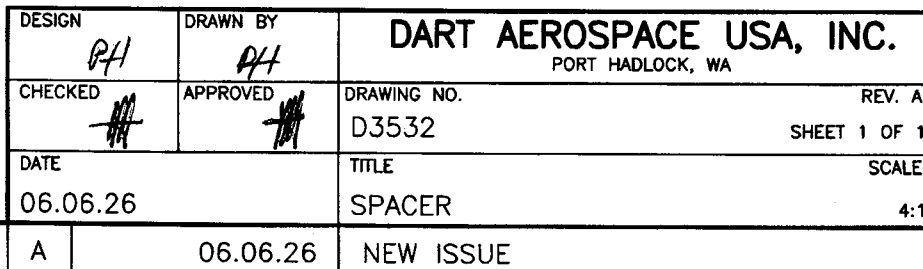
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D3532-1 SPACER

D3532-1 SPACER

- 1) MATERIAL: DELRIN ROUND BAR (REF. DART SPEC. M-DELRIN-RD.DDD)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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ORIGINAL COPY
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128-091-MCS
1501-06

RELEASED
66-66-26

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